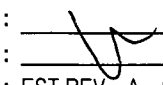


Date: Wednesday, 11/03/2009 1:02:01 PM
 User: Linda Lacelle

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	BRACKET ASSEMBLY	
Job Number :	46462			
Estimate Number :	10770			
P.O. Number :		Part Number :	D3462041	
This Issue :	11/03/2009	S.O. No. :		
Prsht Rev. :	NC	Drawing Number :	D3462 REV C	
First Issue :	/ /	Project Number :	N/A	
Previous Run :	46140	Drawing Revision :	C	
	Type :	Material :		
	LARGE FAB ASSY	Due Date :	20/03/2009	Qty: 5 Um: Each
Written By :				
Checked & Approved By :				
Comment :	EST REV. A 05.11.18 NEW ISSUE EC esr rev B 08.07.15 ecn 1049 EC verified by: DD			

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D34623	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Flange

Pick:

Qty	Part Number	Description	Batch
1	D3462-3	flange	6X B46527

EL 9-5-20

2.0	D34621	BRACKET ASSEMBLY
-----	--------	------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 5.0000 Each(s)

Base Flat Pattern

Pick:

Qty	Part Number	Description	Batch
1	D3462-1F	base flat pattern	6X B46526

EL 9-5-20

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg D3462

EL 9-5-21

4.0	QC9	VISUAL WELDING INSPECTION
-----	-----	---------------------------



Comment: VISUAL WELDING INSPECTION

Cpl 09-05-21

X6

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

S 09/05/22

X6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/15/22	#30	Qty 46 parts were welded 1/8" of diam. R.C. improper holding	MD 29/05/21	Scrap and destroy AND replace Qty 46	MD 29/05/21	N/A	MD 29/05/21	
						9/15/22		

NOTE: Date & initial all entries

Date: Wednesday, 11/03/2009 1:02:01 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46462

Part Number: D3462041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	POWDER COATING	POWDER COATING
-----	----------------	----------------



1111472



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME: 2:00pm

OVEN TEMPERATURE: 460°F

FINISH TIME: 2:30pm

MF 09-05-25 (6)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
-----	-----	---



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 09-05-25 (6)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 57468

MF 09-05-26 (6)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
-----	------	------------------------------



Comment: FINAL INSPECTION/W/O RELEASE

09/05/27 MF

Job Completion



MF 09-05-27

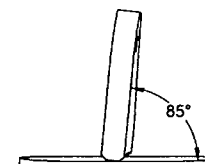
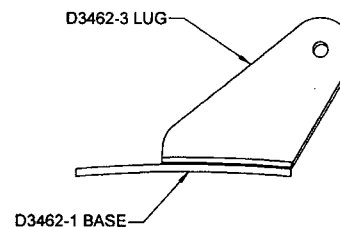
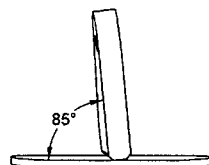
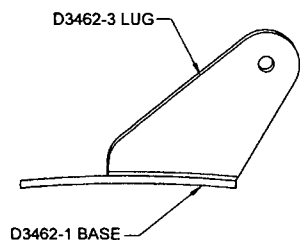
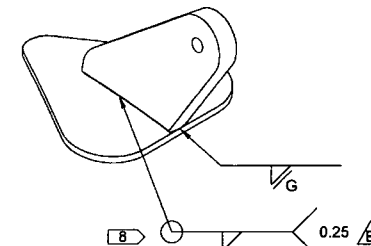
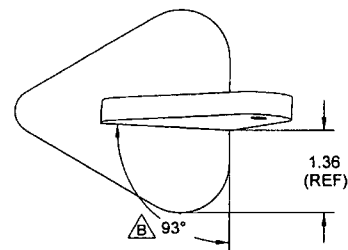
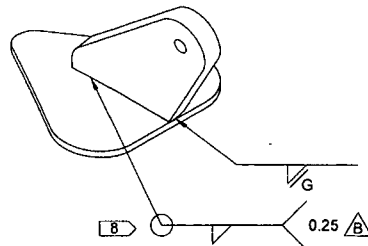
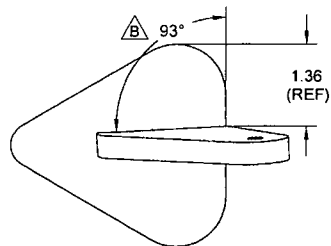
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	IF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	W.D.S. DC.	DRAWING NO.	REV. C
CHECKED	IF	D3462	SHEET 1 OF 2
MFG. APPR.	IF	TITLE	SCALE
APPROVED	IF	BRACKET ASSEMBLY	1:2
DE APPR.	IF	COPY RIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	07.10.24		

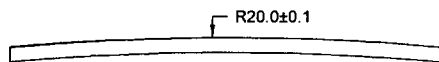
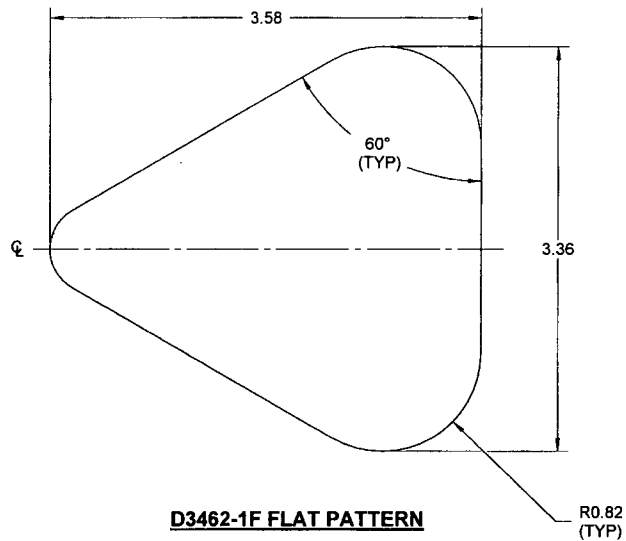
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

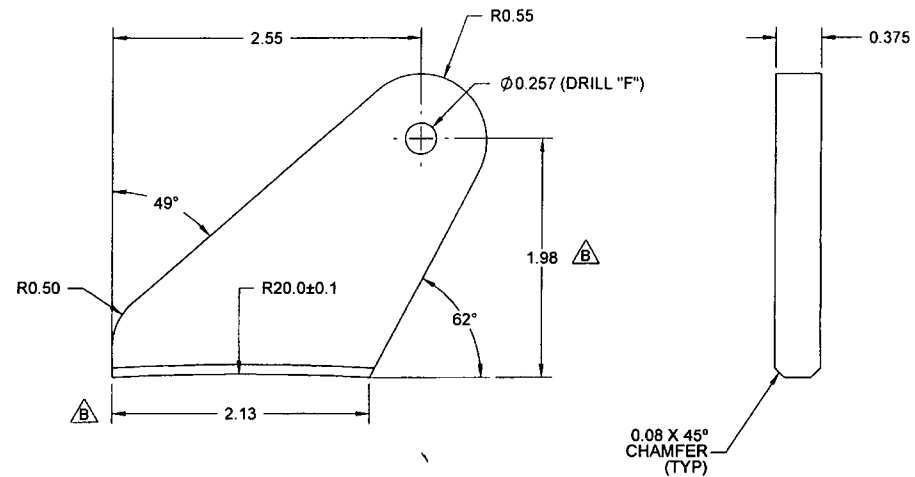
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
PER MIL-S-5019 (ANNEALED), 2B FINISH
(REF. DART SPEC. M304S11GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.28 lbs



- NOTES:**
- 1) MATERIAL: AISI 304 SS BAR
(REF. DART SPEC M304B0.375X03.000)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.47 lbs

RELEASED
8-01-07

DESIGN		DART AEROSPACE LTD	
DRAWN	1/2 20.7.00	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3462	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET ASSEMBLY	1:1
DATE	07.10.24	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT IT			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries